

Work Order ID 104719

104719

Page 1

July-17-13 9:22:28 AM

Item ID: D4635-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Ceiling Panel, LH

Start Date: 7/17/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/25/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-07-17 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4635	C
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100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x/

DAS
07
2-89

13/07/16

SCRAP
Scrap
w/24
change

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150 F

Time IN: 7:00 pm 13/07/15

Time OUT: 7:00 am 13/07/16

x/

DAS
07
2-89

13/07/16

Work Order ID 104719

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Page 2

July-17-13 9:22:28 AM

Item ID: D4635-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Ceiling Panel, LH
 Start Date: 7/17/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/25/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D4635-3 and Folio FTA149 Dwg. Rev. <u>C</u> Folio Rev. <u>C</u> Visually inspect for proper formation and texture	0.00 0.00				<u>X1</u>			13/02/14
130 *130* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00							
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							

Work Order ID 104719

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Page 3

July-17-13 9:22:28 AM

Item ID: D4635-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Ceiling Panel, LH
 Start Date: 7/17/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/25/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

W 13-11-29

Picklist Print

July-17-13 9:22:28 AM

Page 1

Work Order ID: 104719

Parent Item: D4635-3

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 7/17/13

Required Date: 7/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update
12/11/08 DL IPP Rev C Dwg. Ulpdate 13/07/09 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	2,255.4554	8.49	9.4333333			

Kydex steel grey

Location

therm

119476

121902

122181

Loc Qty

2255.455401

120.100001

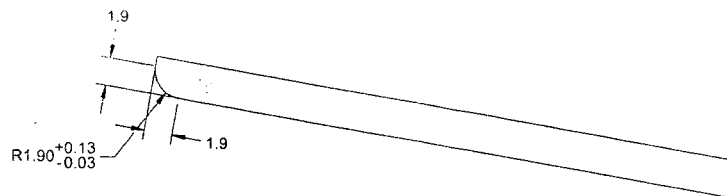
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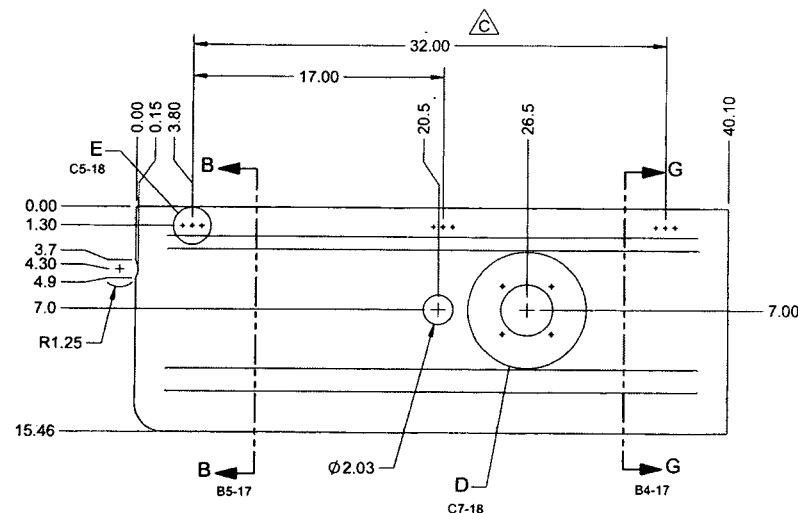
Loc Code

9.44 SF

13/10/11



SECTION H-H 82-15

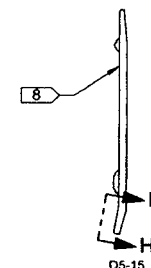


D4635-3 LH, AFT CEILING PANEL

NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

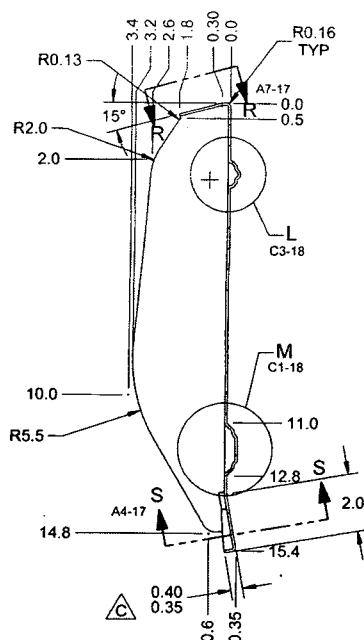
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13-07-17



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2013-07-15
WJ

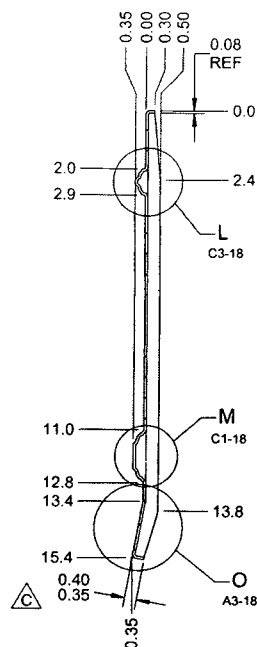
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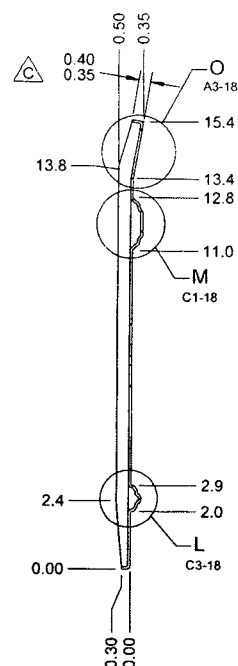
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SECTION A-A' OPPOSITE
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B3-13
B3-14



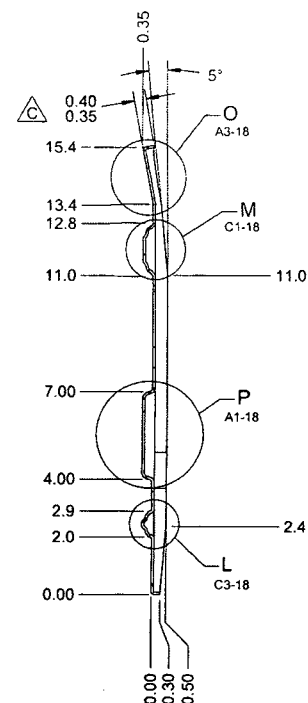
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B7-13
B7-14



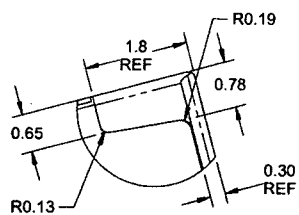
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B4-15
B4-16



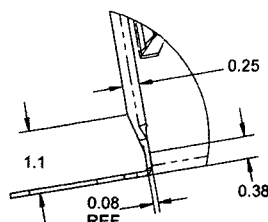
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C6-16



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X

D7-17



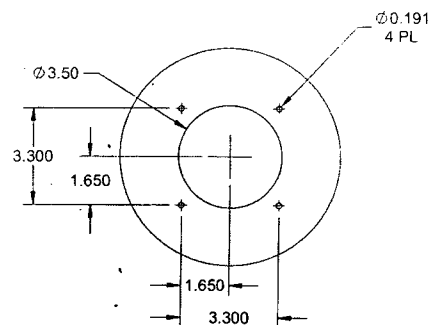
AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

B7-17

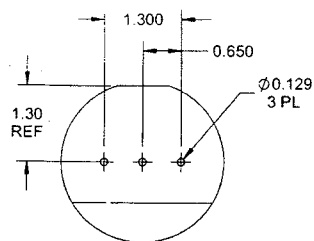
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2013-07-15

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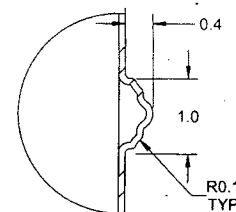
104719



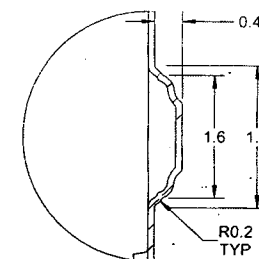
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B3-14
B5-15
B5-16



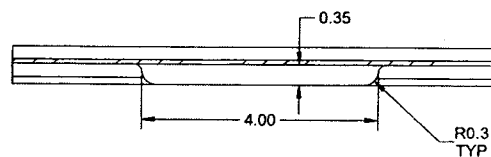
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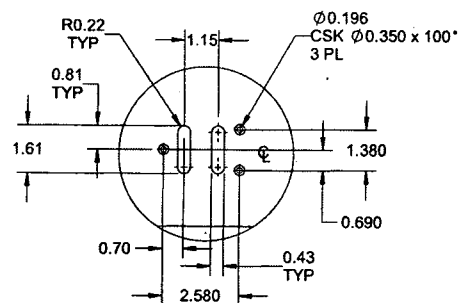
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C7-17



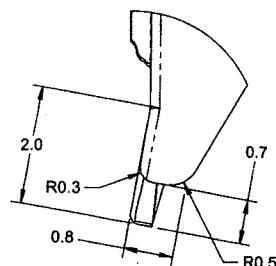
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C3-17
C5-17
C7-17



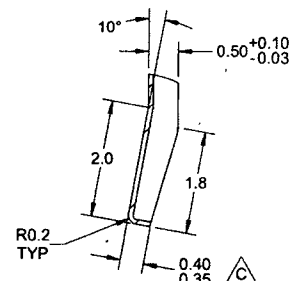
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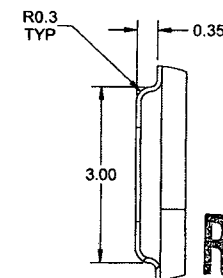
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DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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DART AEROSPACE LTD	Work Order: 104719
Description: AFT CEILING PAWEL, LIT	Part Number: D4635-3
Inspection Dwg: D4635 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: 13/07/16
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.50"		3.51"	✓		Visual	
Ø 2.00"		2.00"	✓		"	
Ø 1.91"		1.91"	✓		"	
Ø 1.29"		1.285"	✓		"	
1.30"		1.3"	✓		"	
R						

Measured by: <u>DL</u>	Date:
Audited by:	Date:
Preliminary Approval:	Date: 1

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.16

NCR: ☒ Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ful Date: 13/12/05QA Closed: OK Date: 13/12/05

Work Order: <u>104719</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4635-3</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>13.3304</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	<u>13/12/04</u>	<u>100</u>	<u>1</u>	<u>AW139 Ceiling panels material have change for</u> <u>Mlexs: 93-FL006-07 and where adding foam sandwich board</u>	<u>✓</u> <u>13.12.04</u>	<u>engineering change material</u>	<u>DAS 27 9-89</u> <u>13/12/04</u>	<u>DAS 27 9-89</u> <u>13/12/04</u>	<u>DAS 27 9-89</u> <u>13/12/04</u>
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input checked="" type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
<u>Engineering change</u>				